

Work Order ID 71678

Thursday, July 07, 2011 12:12:28 PM



Page 1

Item ID: D3259-041

Accept



Setup Start



Revision ID:

Item Name: Access Panel Assembly

Stop



Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *Cd*

Date: 11/07/07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3259	Rev B

100 Pick Kit 0.00



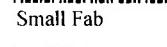
Packaging

Memo

0.00

EP 11/09/20 ④

110 Small Fab 0.00



Small Fab

Memo

0.00

Assemble D3259-041 as per Dwg D3259. Note: Keep .040" Gap all around door.
EP 11/09/20 ④

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Quality Control

Memo

0.00

S. Walker
④
-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71678

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Page 2

Item ID: D3259-041

Accept



Setup Start



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Stop



Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location STK2.Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

4X 11-09-20 LL

W19/01/10

MF
11-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:12:26 PM

Page 1

Work Order ID: 71678



Parent Item: D3259-041



Parent Item Name: Access Panel Assembly

Start Date: 7/7/2011

Required Date: 7/21/2011

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

IPP REV

Start Qty: 4.00

Start Qty: 4.00

Required Qty: 4.00

Required Qty: 4.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Thursday, July 07, 2011 12:12:26 PM

Work Order ID: 71678



Parent Item: D3259-041



Parent Item Name: Access Panel Assembly

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

D3259-7



Door

Manufactured No

110 Each 1.0000

1

4
EB/11/09/20

B71632(4x)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST180	1	
58751	1	

D3260-1



Spring

D3973-5



Receptacle, Rigid, DZUS

Manufactured No

110 Each 0.0000

2

~~EB/11/09/20~~ B71631 (8x)

8
EB/11/09/20

8
EB/11/09/20

D3974-20



Stud, Wing Head, 5/16 DZUS

Manufactured No

110 Each 68.0000

2

8
EB/11/09/20

8
EB/11/09/20

MS20426AD4-4



Rivet

Purchased No

110 Each 2,452.000

4

16
EB/11/09/20

16
EB/11/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

Thursday, July 07, 2011 12:12:26 PM

Work Order ID: 71678



Parent Item: D3259-041



Parent Item Name: Access Panel Assembly

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

MS20470AD3-4



Purchased

No

110

Each

9,156.000

36

144



JS/11/09/20

Rivet,Universal Head

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST319	9156	
111477	8332	
15541	824	

MS20470AD3-5



Purchased

No

110

Each

3,892.000

10

40



JS/11/09/20

Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST319	3892	
104817	3030	
9682	862	

40

JS/11/09/20
A3972-S

Qty 2

B: M115178

JS/11/09/20

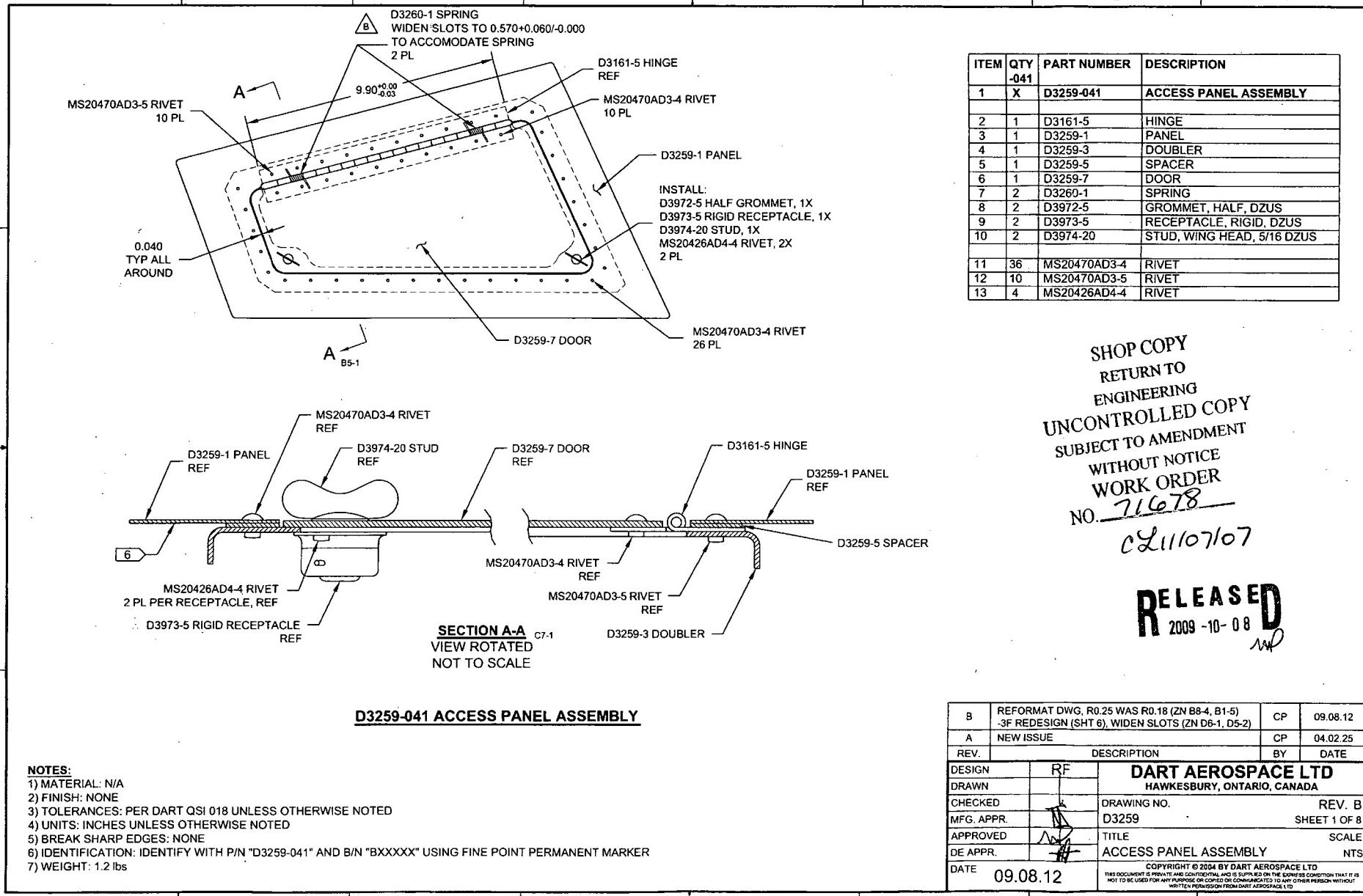
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

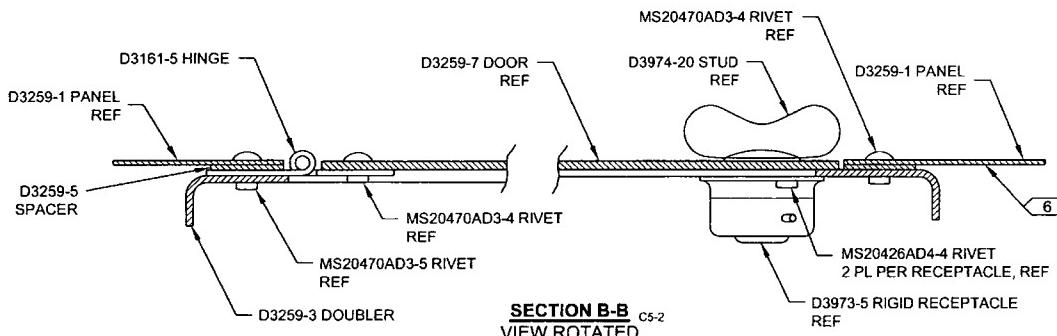
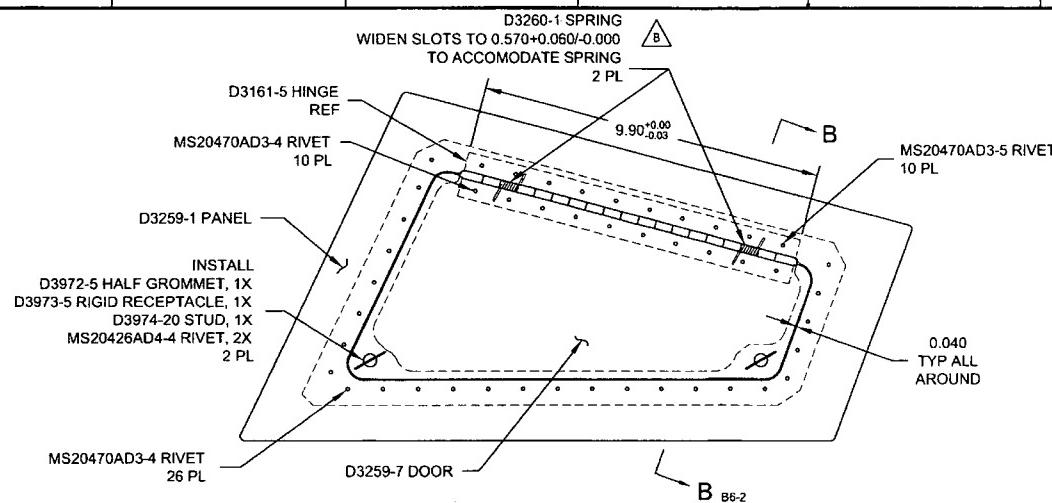
8 7 6 5 4 3 2 1



B	REFORMAT DWG, R0.25 WAS R0.18 (ZN B8-4, B1-5) -3F REDESIGN (SHT 6), WIDEN SLOTS (ZN D6-1, D5-2)		CP	09.08.12
A	NEW ISSUE		CP	04.02.25
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		DRAWING NO. D3259		
CHECKED		REV. B SHEET 1 OF 8		
MFG. APPR.		TITLE ACCESS PANEL ASSEMBLY		
APPROVED		SCALE NTS		
DE APPR.		DATE 09.08.12		

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WRITTEN PERMISSION FROM DART AEROSPACE LTD

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-042	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-4	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



D3259-042 ACCESS PANEL ASSEMBLY

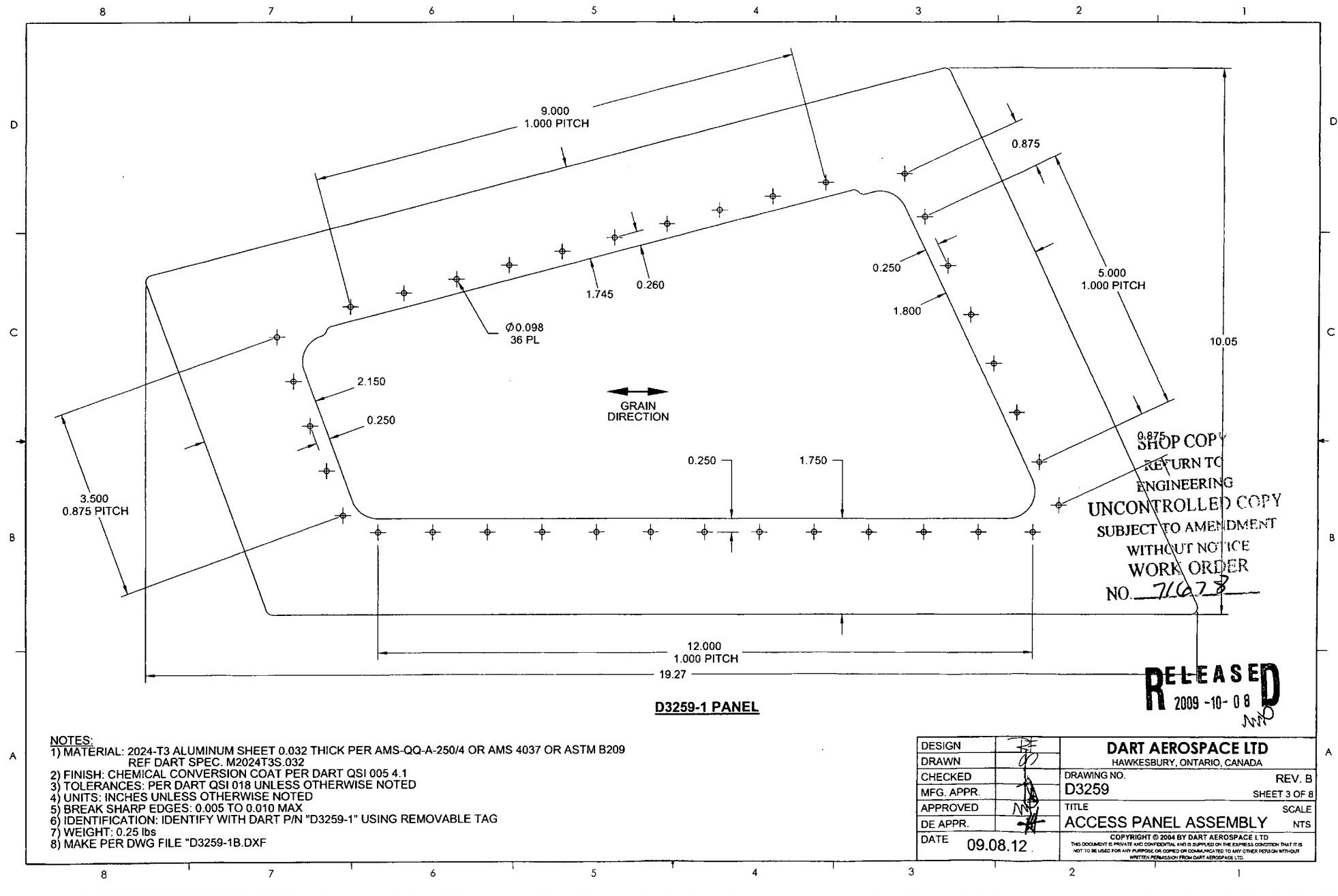
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71678

RELEASED
2009-10-08

DESIGN	RF	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. B
APPROVED		D3259
DE APPR.		SHEET 2 OF 8
DATE	09.08.12	TITLE
		SCALE
		NTS
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NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032
REF DRAFT SPEC. M2024T3S-032

REF DART SPEC. M202413S.032
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 009

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE STATED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

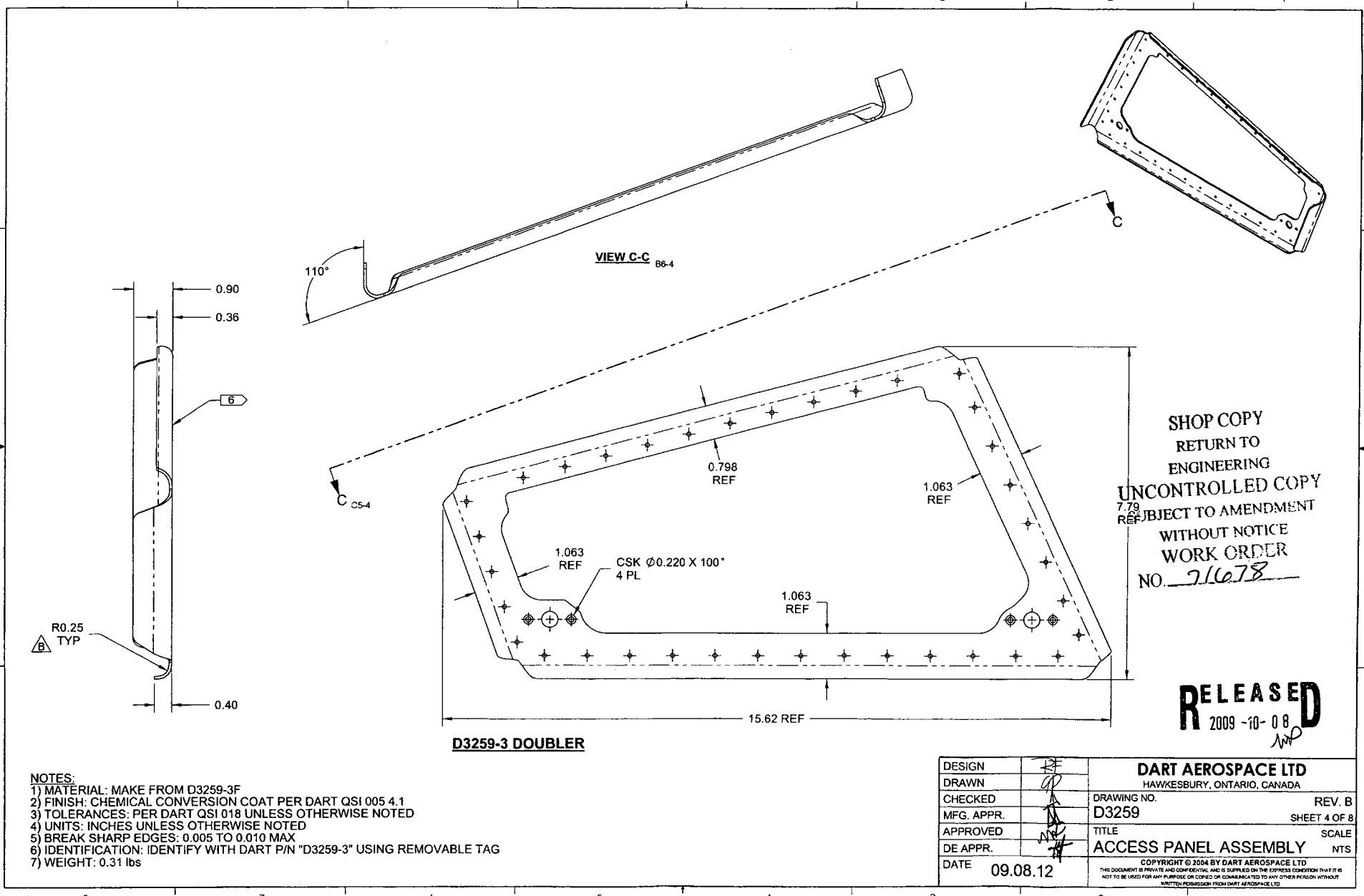
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-1" USING REMOVABLE TAG

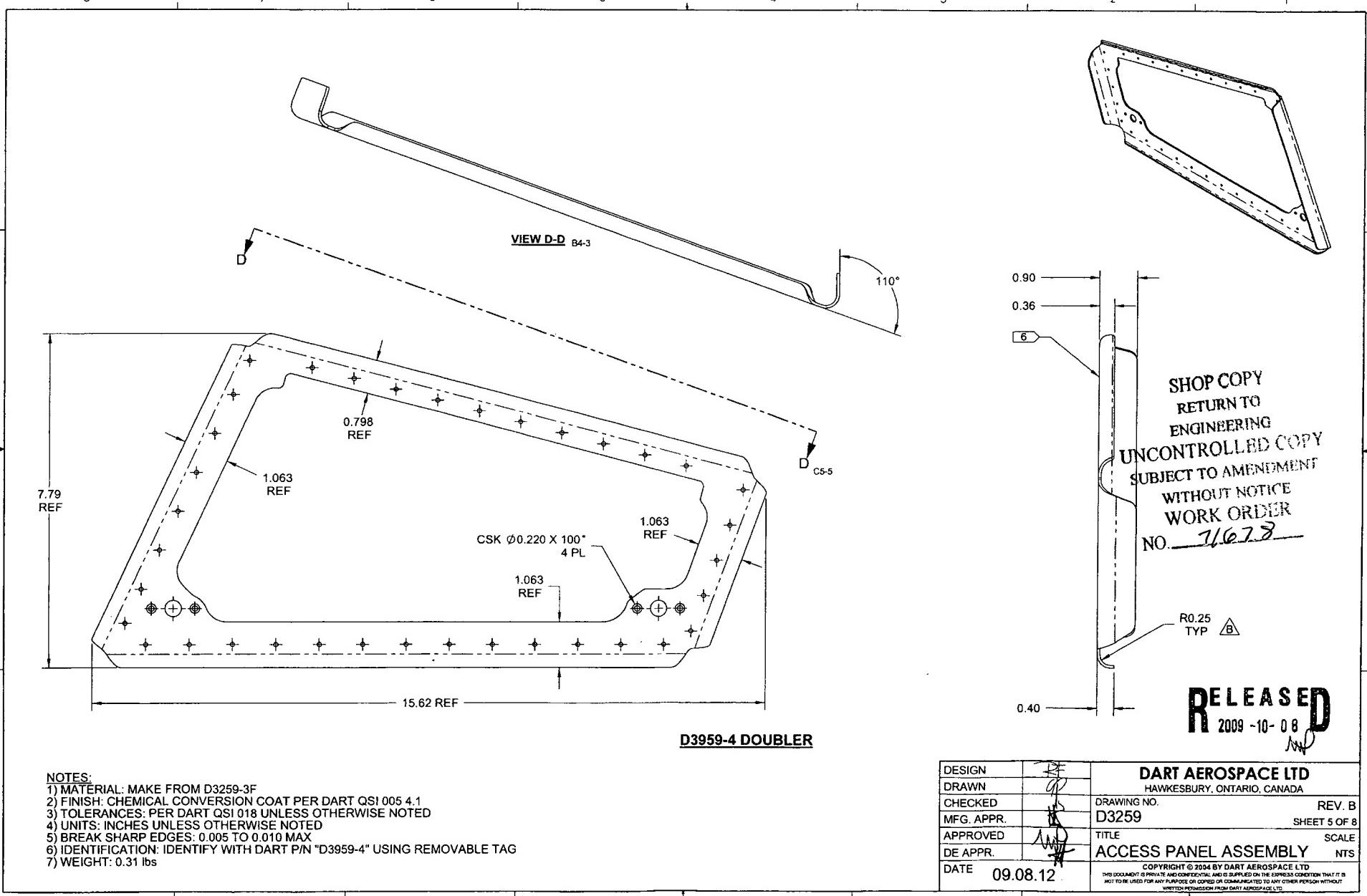
7) WEIGHT: 0.25 lbs

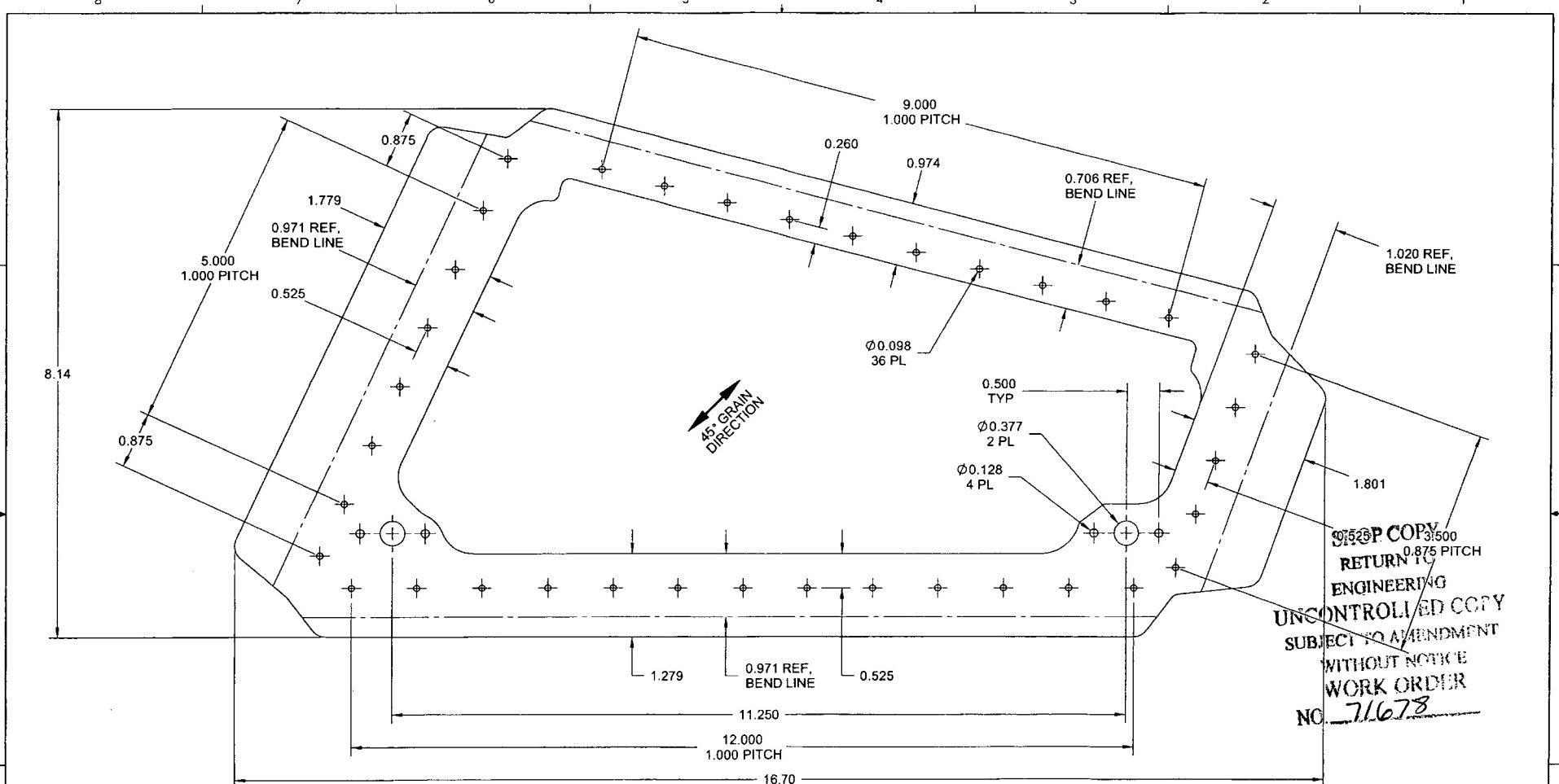
8) MAKE PER DWG

8) MARKETING BUDGETS IN DOLLARS

DESIGN	<i>PF</i>	DART AEROSPACE LTD	
DRAWN	<i>DP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i> </i>	DRAWING NO.	REV. B
MFG. APPR.	<i> </i>	D3259	SHEET 3 OF 8
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i> </i>	ACCESS PANEL ASSEMBLY NTS	
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D3259-3F DOUBLER

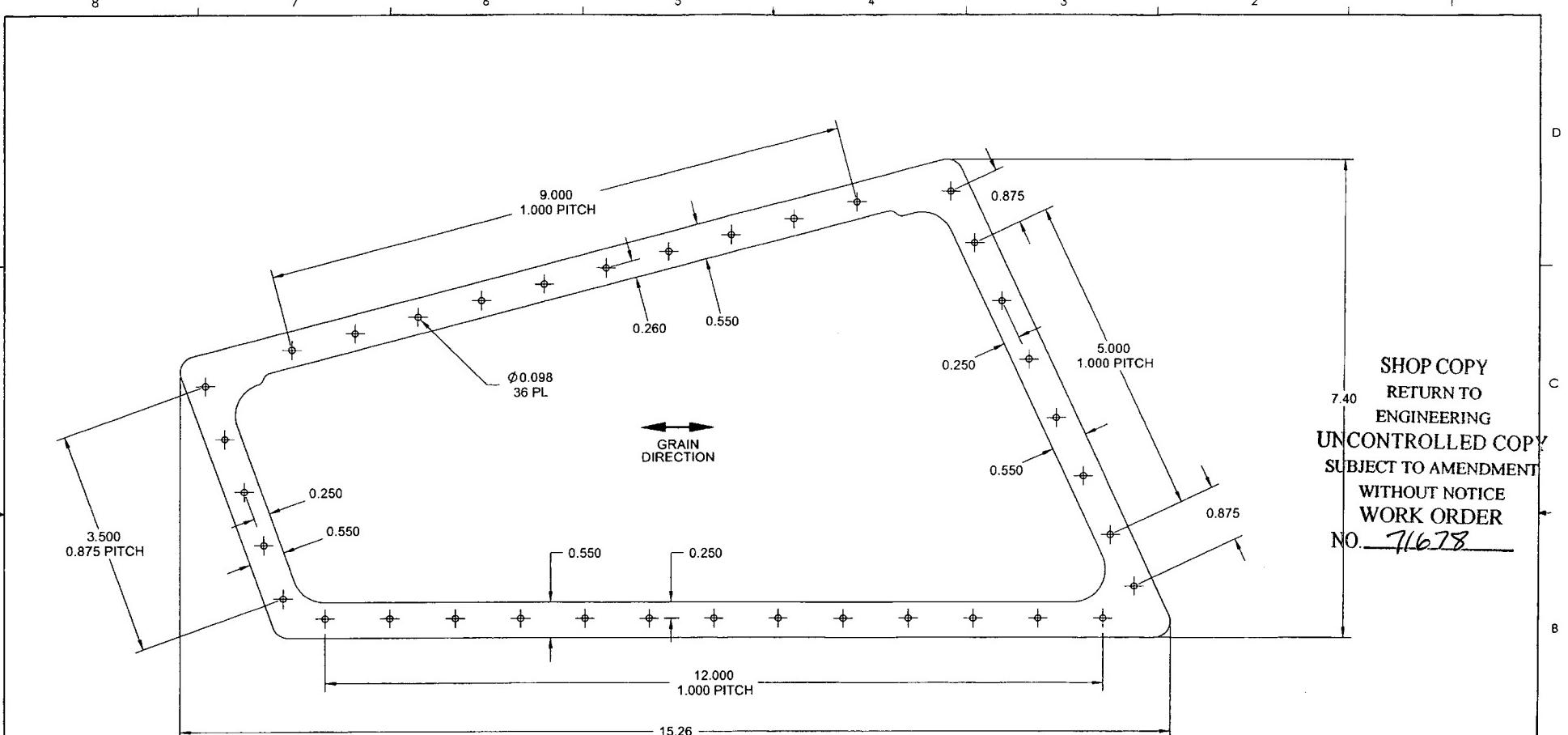
NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.31 lbs
- 8) MAKE PER DWG FILE "D3259-3FB.DXF"

DESIGN	PF	DART AEROSPACE LTD
DRAWN	GP	HAWKSLEY, ONTARIO, CANADA
CHECKED	JK	REV. B
MFG. APPR.	JK	DRAWING NO. D3259
APPROVED	JK	SCALE NTS
DE APPR.	JK	TITLE ACCESS PANEL ASSEMBLY
DATE	09.08.12	REVISION SHEET 6 OF 8

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RELEASED
2009-10-08
JK



D3259-5 SPACER

RELEASED
2009-10-08

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-5" USING REMOVABLE TAG
 - 7) WEIGHT: 0.07 lbs
 - 8) MAKE PER DWG FILE "D3259-5B.DXF

DESIGN	<u>BF</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<u>GP</u>			
CHECKED	<u>AS</u>	DRAWING NO.	REV. B	
MFG. APPR.	<u>TG</u>	D3259	SHEET 7 OF 8	
APPROVED	<u>JW</u>	TITLE	SCALE	
DE APPR.	<u>JW</u>	ACCESS PANEL ASSEMBLY	NTS	
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